

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017977**Date Inspected:** 18-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	An Qing Xing	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG COMPONENT	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG segment 10BE, weld No. OBE10D-013/014. The welder is identified as #056200. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 4G position for the OBG segment 11AE to 11BE, weld No. SEG068B-057. The welder is identified as #044515. ZPMC QC is identified as Mr. Liu Dao Feng. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Ultrasonic Testing (UT) at CB16

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG cross beam weld joints.

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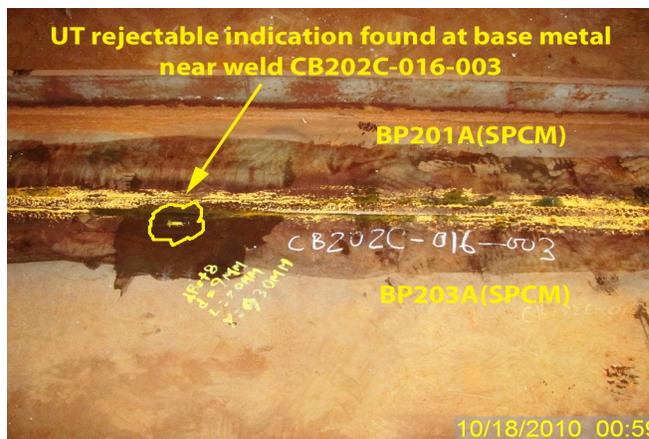
The welds designation reviewed are as follows:

CB202A-016-005,017  
CB202B-016-001~004

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Cross Beam CB16, this Quality Assurance Inspector (QA) discovered the following issues One (1) longitudinal linear Class "A" rejectable indication measuring approximately 20mm in length. The indication dbS rating is a +8. Material thickness is 14mm. The depth of the indication is approximately 9mm. The weld is identified as CB202C-016-003. The weld is Complete Joint Penetration (CJP) butt joint. The splice joint joining between Bottom Plate BP203A to Bottom Plate BP201A. The weld is designated as seismic Performance Critical Material (SPCM). The indication is in base metal and 27mm from weld toe, clearly marked near the weld. The Y distance for this indication is 930 mm from floor beam FB205-050. Bottom Plate BP203A is located at backside of bay#16. The Notice of Witness Inspection (NWIT) No. is 007010. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

This QA inspector generated an incident report on this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

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**Reviewed By:** McClendon, Timothy

QA Reviewer